

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-029370**Date Inspected:** 01-Apr-2013**Project Name:** SAS Superstructure**OSM Arrival Time:** 600**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1630**Contractor:** American Bridge Manufacturer in Reedsport, Oregon**Location:** Reedsport, Oregon**CWI Name:** David Speakman**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Handrail posts/Cable Bands**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QAI) James Doe was at the offsite fabrication facility of American Bridge Manufacturing (ABM) between times noted above in order to monitor Quality Control functions and the in process work being performed by ABM personnel. The following items were observed:

The QAI witnessed work in progress related to CCO 188 (OBG Cable Safety Railing):

This QAI observed ABM personnel performing fit up and tack welding operations of multiple parts for the handrail posts (M2 post assemblies). The ABF approved drawing numbers utilized were sheet number 304AD. The parts fit were mark # M2. The ABM Welder was Ryan Whitman (W) utilizing ABM FCAW WPS #ABM-SAS-35 and WPS #ABM-SAS--06

The QAI observed ABM Certified Welding Inspector (CWI), David Speakman & Assistant Quality Control Inspector (QCI) Tony Corsaletti monitoring the welding parameters, fit-up/welding operations, checking pre-heat/interpass temperatures, perform dimensional and visual inspection. This QAI checked the welding parameters using a calibrated Fluke meter, Volts- 149 and Amps- 26.5, which appeared to be in compliance with the WPS noted above. The QAI observed that items witnessed appeared to be in conformance with the approved drawings noted above, the standard specification and special provisions.

The QAI witnessed work in progress related to CCO 274 (Supplemental Cable Band Collars):

This QAI observed ABM personnel performing fit up and tack welding operations of multiple parts for the cable

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band collar, piece mark #2 and #3. The ABF approved drawing sheet # CCO-274-1/3. The ABM Welder was Brian Moore (ID# B) and Cody Greer (ID# G) utilizing FCAW WPS #ABM-SAS-025 and WPS #ABM-SAS-08.

The QAI observed ABM Quality Control Inspector (QCI) Mike Inman and Assistant Quality Control Inspector (aQCI) Tony Corsaletti monitor the fit up and welding operations, checking pre-heat/interpass temperatures, perform dimensional and visual inspection. This QAI checked the welding parameters using a calibrated Fluke meter, Volts- 250 and Amps- 26.2, which appeared to be in compliance with the the WPS noted above. The QAI observed aQCI Tony Corsaletti perform 100% magnetic particle testing on the CJP root passes and cap passes of the cable band collar clamps, Piece #'s 2 and 3. This QAI was notified by aQCI, that no indications were noted. The QAI observed that items witnessed appeared to be in conformance with the approved drawings noted above, the standard specification and special provisions. This Inspection report was performed by James Doe Lot# B358.



Summary of Conversations:

No significant conversations held on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916)764-6027, who represents the Office of Structural Materials for your project.

Inspected By:	Riley, Ken	Quality Assurance Inspector
Reviewed By:	Foerder, Mike	QA Reviewer
